

ABSTRACT

5 The present invention provides a titanium-made plate-type heat
exchanger comprising first-fluid flow paths and second-fluid flow paths
arranged alternately, which is formed by joining titanium-made constituting
members, wherein: a titanium-zirconium based brazing solder containing 20
to 40 wt.% of titanium and 20 to 40 wt.% of zirconium, which melts under
880°C, is coated over positions to be connected of the constituting members,
10 and brazing solder coated constituting members are heated under 880°C in an
vacuum and/or inert gas atmosphere. The present invention also provides a
production method of the heat exchanger, which can prevent titanium-made
constituting members of the heat exchanger from being deteriorated due to
over-heating.